

**What is Claimed:**

1. A liquid crystal display having a first substrate and a second substrate which are disposed with a predetermined gap therebetween, in which liquid crystal is sealed in said gap, comprising:

post structures for controlling the gap between said first substrate and said second substrate;

a sealing material provided outside a display area for sealing said liquid crystal in said gap, and forming an open injection hole for injecting said liquid crystal therethrough;

an end-sealing material for sealing said injection hole after said liquid crystal is sealed in; and

injection hole post structures provided in an area near said injection hole, for dividing said injection hole into a plurality of portions by using the same material as said post structures.

2. The liquid crystal display according to Claim 1, wherein said injection hole post structures divide the width of said injection hole into 100  $\mu$ m to 3 mm.

3. The liquid crystal display according to Claim 1, wherein said injection hole post structures are formed

with a height lower than the height of the gap formed by  
said first substrate and said second substrate.

4. The liquid crystal display according to Claim  
1, wherein said injection hole post structures are formed  
5 from a material which deteriorates the charge retention of  
said liquid crystal less than said sealing material.

5. The liquid crystal display according to Claim  
1, wherein said injection hole post structures are formed at  
a position where part of them are in contact with said  
10 end-sealing material.

6. A liquid crystal display, comprising:  
a sealing material for connecting a pair of  
substrates outside the display area, and forming an open  
injection hole for injecting liquid crystal therethrough;  
15 an end-sealing material for sealing said injection  
hole after said liquid crystal is injected; and  
a penetration suppressor provided near a  
connection portion between said sealing material and said  
end-sealing material for suppressing the penetration of a  
20 pollutant generated from said connection portion into said  
display area.

7. The liquid crystal display according to Claim 6, wherein said sealing material has a projecting portion formed by bending said sealing material at an acute angle when said injection hole is formed.

5 8. The liquid crystal display according to Claim 7, wherein said penetration suppressor is a pair of post structures which is close to said projecting portion and extending from the vicinity of the substrate end in said injection hole to said display area.

10 9. A liquid crystal display in which liquid crystal is sealed in the gap formed by a pair of substrates to display pictures on a display area, comprising:

15 post members formed, after a pattern, on one substrate of said pair of substrates for controlling said gap;

a sealing material provided outside said display area for sealing said liquid crystal in said gap, and forming an open injection hole for injecting said liquid crystal therethrough;

20 an end-sealing material for sealing said injection hole after said liquid crystal is sealed in; and

5 a plurality of injection hole post structures  
provided between the substrate end in said injection hole  
and said display area on said one substrate, and formed  
after a pattern similarly to said post members, for  
preventing the pollutant seeped from said end-sealing  
material from penetrating into said display area.

10 10. The liquid crystal display according to Claim 9,  
wherein said plurality of injection hole post structures  
forms injection hole post structures of a plurality of rows  
toward said display area from a position close to the  
substrate end in said injection hole.

15 11. The liquid crystal display according to Claim  
10, wherein those of the injection hole post structures  
forming said plurality of rows which are close to the  
substrate end in said injection hole are disposed at the  
position where they are in contact with said end-sealing  
material.

20 12. A liquid crystal display having a first  
substrate and a second substrate which are disposed with a  
predetermined gap therebetween, in which liquid crystal is  
sealed in said gap, comprising:

a sealing material provided outside a display area for sealing said liquid crystal in said gap, and forming an open injection hole for injecting said liquid crystal therethrough; and

5 a plurality of injection hole post structures provided in an area near said injection hole at a distance D from said display area, and respectively disposed with a predetermined space therebetween, wherein said predetermined space formed by said plurality of injection hole post  
10 structures is shorter than double said distance D.

13. A method for manufacturing a liquid crystal display, comprising:

a post structure forming step of applying a resin to a first substrate, and using said resin to form,  
15 after a pattern, post members for controlling the cell gap between a second substrate opposing to said first substrate, and injection hole post structures provided in the vicinity of the injection hole for liquid crystal;

a sealing material applying step of applying a  
20 sealing material surrounding the outside of the display area in said first substrate and forming said injection hole;

a bonding step of disposing and pressing said opposing second substrate against said first substrate

applied with the sealing material by said sealing material  
applying step, thereby to bond said first substrate and said  
second substrate by means of said sealing material;

5 a liquid crystal injecting step of injecting  
liquid crystal from said injection hole into the gap between  
said first substrate and said second substrate bonded by  
said bonding step; and

an end-sealing material charging step of charging an  
end-sealing material for sealing said injection hole.

10 14. The method for manufacturing a liquid crystal  
display according to Claim 13, wherein in said sealing  
material applying step, said sealing material is applied to  
a position where it is not in contact with said injection  
hole post structures formed after a pattern by said post  
15 structure forming step.

15 15. The method for manufacturing a liquid crystal  
display according to Claim 13, wherein in said post  
structure forming step, a photosensitive resin is applied to  
said first substrate, and said resin is hardened after  
20 exposed to UV rays using a photomask.